

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 152764

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152764

Page 2

Item ID: D206-797-211 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L / L1 / L3 / L4 Quick Release Mounting Provisions - Fits LH or RH
Start Date: 10/26/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00				DAS 28 9-89	DAS 27 9-89		
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-797-211 Location: FG034								FEB 16 2017
140	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89			
140									
QC	Memo	0.02							FEB 16 2017
Quality Control									

DAS
21
9-89

FEB 16 2017

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
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OTHER : ☐					

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Work Order ID: 152764

152764

Parent Item: D206-797-211

D206-797-211

Parent Item Name: 206L / L1 / L3 / L4 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 10/26/2016

Required Date: 11/7/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.10 as per IIN rev.A DD verf:JLM IPP Rev:B
11.04.18 MS24694-10 TO MS24694-S10 DD verf:JLM IPP Rev:C 11.04.19
added(1) D4293-1(was missing) DD verf:JLM IPP Rev:D 11.09.12 @ chg
002 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4713-1 *D4713-1* Spacer		Manufactured	No			110	Each	44.0000	1	1	DAS 6 9-89	FEB 15 2017	DAS 27 9-89
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST121				44					
				146084				44					
MS3367-5-0 *MS3367-5-0* Tie Wrap		Purchased	No			110	Each	88.0000	1	1	DAS 6 9-89	FEB 15 2017	DAS 27 9-89
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST272				88					
				123164				88					
D4271-011 *D4271-011* Beam Assembly, Fwd		Manufactured	No			110	Each	5.0000	1	1	DAS 6 9-89	FEB 15 2017	DAS 27 9-89
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST452				5					
				145658				2					
				145659				2					
				151055				1					

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Parent Item Name: 206L / L1 / L3 / L4 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 10/26/2016

Required Date: 11/7/2016

Start Qty: 1.00

Required Qty: 1.00

D4271-013

Manufactured No

110

Each

1.0000

1 1

D4271-013

Beam Assembly, Aft

DAS
28
9-89

**

DAS
6
9-89

DAS
27
9-89

FEB 15 2017

Location

Loc Qty

Loc Code

ST453

1

146767

1

D4292-1

Manufactured No

110

Each

0.0000

2 2

D4292-1

Fitting

DAS
28
9-89

**

DAS
6
9-89

DAS
27
9-89

FEB 15 2017

D4293-1

Manufactured No

110

Each

8.0000

2 2

D4293-1

Fitting

DAS
28
9-89

**

DAS
6
9-89

DAS
27
9-89

FEB 15 2017

Location

Loc Qty

Loc Code

st533

8

122955

8

D4314-1

Manufactured No

110

Each

21.0000

4 4

D4314-1

Shim

DAS
28
9-89

**

DAS
6
9-89

DAS
27
9-89

FEB 15 2017

Location

Loc Qty

Loc Code

ST091

21

123102

9

151130

8

151796

4

D4314-3

Manufactured No

110

Each

27.0000

4 4

D4314-3

Shim

DAS
28
9-89

**

DAS
6
9-89

DAS
27
9-89

FEB 15 2017

Location

Loc Qty

Loc Code

ST091

27

119651

7

123115

20

Monday, November 07, 2016 3:09:22 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

Picklist Print

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Page 3

Work Order ID: 152764

152764

Parent Item: D206-797-211

D206-797-211

Parent Item Name: 206L / L1 / L3 / L4 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 10/26/2016

Required Date: 11/7/2016

Start Qty: 1.00

Required Qty: 1.00

AN6-17A

Purchased

No

110

Each

20.0000

2 2

AN6-17A

Bolt

**

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST334

20

m130466

10

m135671

10

AN6-20A

Purchased

No

110

Each

35.0000

2 2

AN6-20A

BOLT

**

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

over005

20

M134943

20

ST334

15

M133932

15

NAS1149D0663J

Purchased

No

110

Each

937.0000

8 8

NAS1149D0663.J

Washer

**

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260

215

M131618

215

ST260a

500

M135948

500

ST263

222

M135464

222

136192

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coor. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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OTHER :																																																																							

Picklist Print

Monday, November 07, 2016 3:09:22 PM

Page 4

Work Order ID: 152764

152764

Parent Item: D206-797-211

D206-797-211

Parent Item Name: 206L / L1 / L3 / L4 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 10/26/2016

Required Date: 11/7/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased No

110 Each

326.0000

4 4

MS21042L6

Nut

**

DAS
6
9-89

FEB 15 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

OVER007

100

m135979

100

ST303

226

m135442

26

m135704

100

m135864

100

MS27151-19

Purchased No

110 Each

49.0000

4 4

MS27151-19

NUT

**

DAS
6
9-89

FEB 15 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

ST275

49

m132285

18

m132399

31

MS24694-S10

Purchased No

110 Each

124.0000

4 4

MS24694-S10

SCREW

**

DAS
6
9-89

FEB 15 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

ST284

124

117442

24

120986

100

Monday, November 07, 2016 3:09:22 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 152764

Tuesday, February 14, 2017 11:55:46 AM

152764

Page 1

Item ID: D206-797-211**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** 206L / L1 / L3 / L4 Quick Release Mounting Provisions - Fits LH or RH**Start Date:** 10/26/2016 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 11/7/2016 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-797-2	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD206-797-211 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

FEB 15 2017

5.0 PARTS LIST

Qty -021	Qty -022	Qty -023	Qty -024	Qty -211	Part Number	Description
X					D206-797-021	QUICK RELEASE HELI-UTILITY-BASKET
	X				D206-797-022	QUICK RELEASE HELI-UTILITY-BASKET
		X			D206-797-023	QUICK RELEASE HELI-UTILITY-BASKET
			X		D206-797-024	QUICK RELEASE HELI-UTILITY-BASKET
1	1	1	1	X	D206-797-211	QUICK RELEASE BASKET MOUNTING KIT
1					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
	1				D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
		1			D4272-013	BASKET ASSY, LIGHT WEIGHT LID, LH
			1		D4272-014	BASKET ASSY, LIGHT WEIGHT LID, RH
				1	D4271-011	BEAM ASSY, FWD
				1	D4271-013	BEAM ASSY, AFT
				2	D4292-1	FITTING
				2	D4293-1	FITTING
				4	D4314-1	SHIM
				4	D4314-3	SHIM
				1	D4713-1	SPACER
				2	AN6-17A	BOLT
				2	AN6-20A	BOLT
				8	NAS1149D0663J	WASHER (OR AN960JD616)
				4	MS21042L6	NUT (OR MS21042-6)
				4	MS27151-19	NUT
				4	MS24694-10	SCREW
				1	MS3367-5-0	TIE WRAP